

Work Order ID 135487

Wednesday, August 12, 2015 4:30:45 PM

135487

Page 1

Item ID: D4925-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: EAPS Mounting Plate

Stop ***NS2***Start Date: 8/12/15 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 8/12/15 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: AUG 14 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4925	D

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4925

Dwg Rev: DProg Rev: D

2-Deburr as required

Q08/15/09/17

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

Q08/15/09/17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																															
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135487

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 8/12/15 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 8/12/15 **Req'd Qty:** 2.00 ***Q***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
38
9-89
SEP 17 2015

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

C'sink and bend tabs as per dwg

**DAS
30
9-89**

15/09/18

140

QC5- Inspect part completeness to step on W/O

0.00

140

OC

Memo

0.00

Quality Control

DAS
38
~~9-89~~
SEP 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Wednesday, August 12, 2015 4:30:45 PM

135487

Page 3

Item ID: D4925-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: EAPS Mounting Plate

Stop ***NS2***

Start Date: 8/12/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/12/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00				2	FF	SEP 2 1 2015	
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00			DAS 30 9-89	2			SEP 2 1 2015
170									
QC	Memo	0.00							
Quality Control									
175	QC5- Inspect part completeness to step on W/O	0.00							
175									
QC	Memo	0.00				(2)			DAS 38 9-89
Quality Control									

SEP 2 1 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EAPS Mounting Plate

Start Date: 8/12/15 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 8/12/15 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
180				DAS					
Packaging	Memo	0.00		30		<u>2</u>			SEP 21 2015
Packaging				9-89					
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MCS

SEP 21 2015

127
St

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																				
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OTHER : ☐																																																																							

Picklist Print

Wednesday, August 12, 2015 4:30:44 PM

Page 1

Work Order ID: 135487

135487

Parent Item: D4925-1

D4925-1

Parent Item Name: EAPS Mounting Plate

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-08-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No				sf	387.3363		8.631579			

M6061T6S 06.3

6061-T6 .063 Sheet

08/15/09/17

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	48.75	
M131653	48.75	
MAT021	338.5863	
M128941	7.932	
M129845	29.2743	
M130096	18.2	
M131322	69.83	
M131383	39.5	
M132358	173.85	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

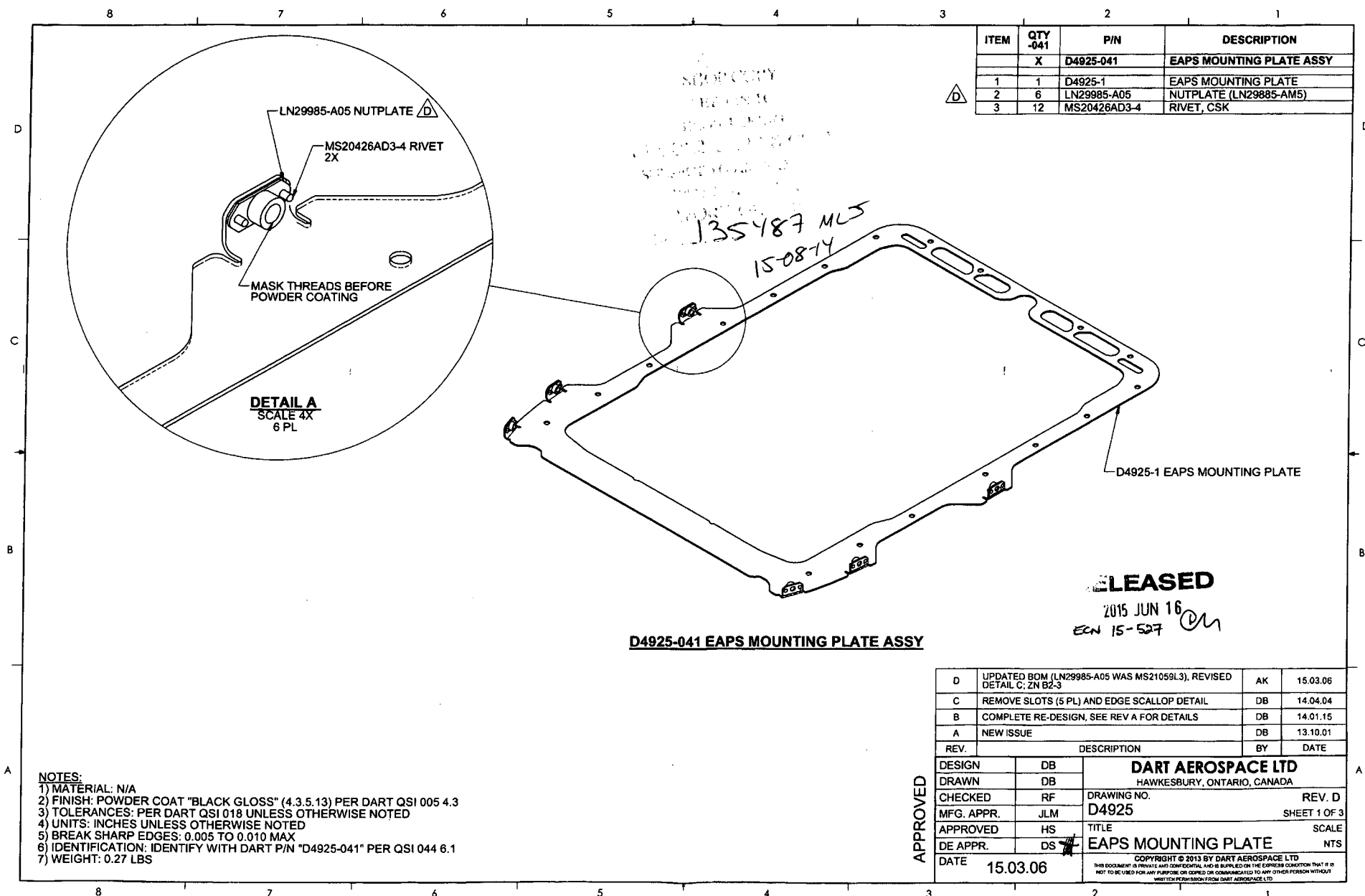
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

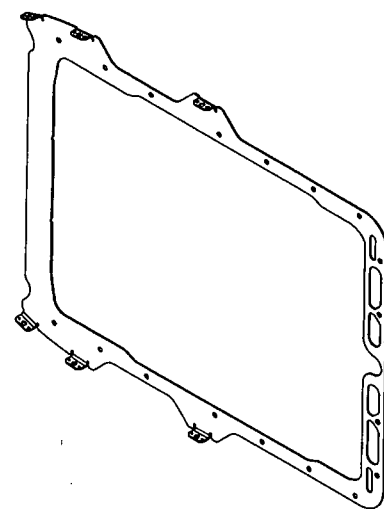
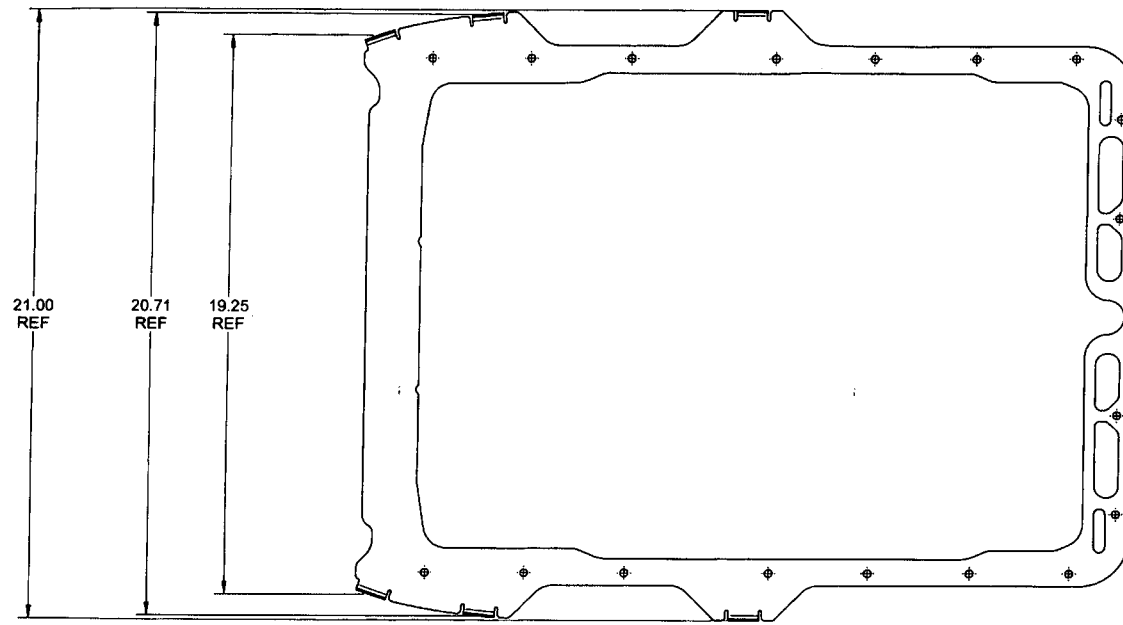
ITEM	QTY	P/N	DESCRIPTION
	X	D4925-041	EAPS MOUNTING PLATE ASSY
1	1	D4925-1	EAPS MOUNTING PLATE
2	6	LN29985-A05	NUTPLATE (LN29885-AM5)
3	12	MS20426AD3-4	RIVET, CSK

△



8 7 6 5 4 3 2 1

D
C
B
A



D4925-1 EAPS MOUNTING PLATE
(MAKE FROM D4925-1F)

R0.13
SECTION B-B
SCALE 2X

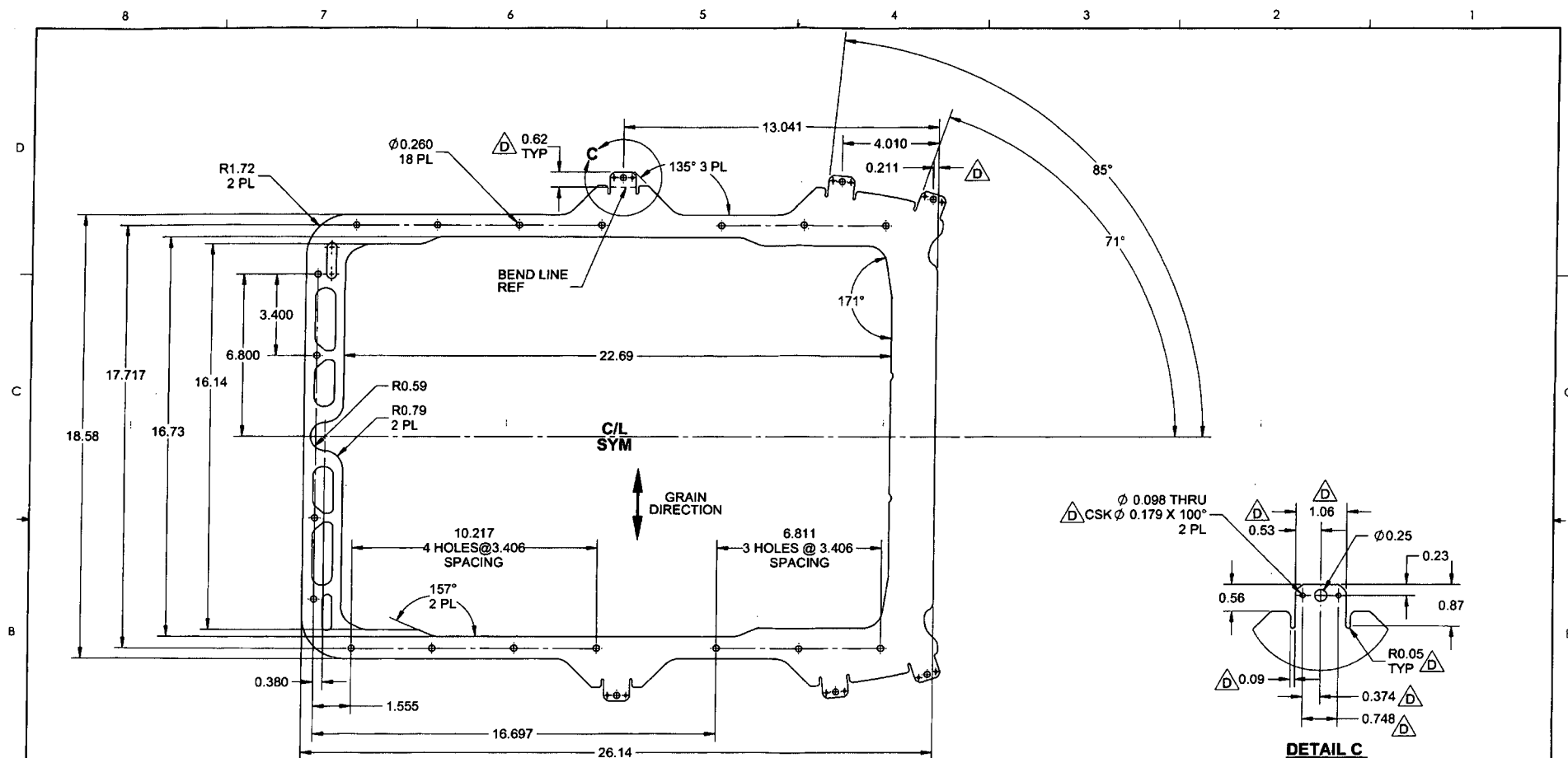
RELEASED
2015 JUN 18

- NOTES:
- 1) MATERIAL: MAKE FROM D4925-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4925	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	EAPS MOUNTING PLATE	NTS
DATE	15.03.06	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

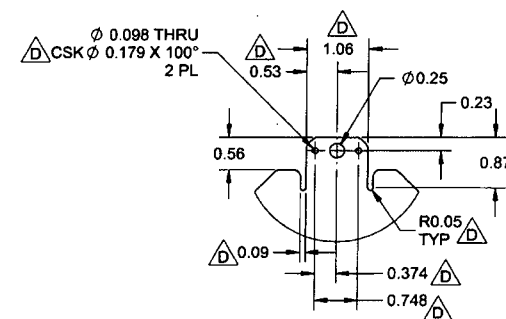
8 7 6 5 4 3 2 1



D4925-1F EAPS MOUNTING PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 0.063 THICK
REF DART SPEC M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT 0.26 LBS
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D4925-1F Rev D.DXF".



DETAIL C
SCALE 2X
6 PL

RELEASED

2015 JUN 16

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4925	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	EAPS MOUNTING PLATE	NTS
DATE	15.03.06	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	